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VIBRATION GENERATING DEVICE OF SMALL WIRELESS MACHINE

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BACKGROUND OF THE INVENTION

[Technical Field of the Invention]

The present invention relates to a vibration generating device used for a call or the like of a small wireless machine for example, a portable or mobile telephone.

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[Prior Art]

In recent years, as a kind of a small wireless machine, such as a paging system small wireless calling machine, a PHS, or a portable, mobile telephone, a machine of a type having a built-in vibration generating device made by eccentrically coupling a vibrator of high specific gravity metal to a rotating shaft of a motor ^{has} become popular. According to the small wireless calling machine or the like having such a built-in vibration generating device, instead of generation of a ringing tone, a vibration is generated by the rotation of the vibrator so that it is possible to confirm reception without ^{Knowledge by} being known to another person even in, for example, a crowd or a meeting.

Conventionally, the vibration generating device of this kind of small wireless machine is constructed such that a vibrator ^{of} ~~formed into~~ a non-cylindrical shape is integrally coupled with a rotating shaft of a small motor connected to a signal generating circuit of the small wireless machine.

This vibrator is made of a high specific gravity metal molded ^{pre-forming} by a powder metallurgical method. ^A cylindrical boss portion is integrally formed at an eccentric load portion of a substantially fan-shaped section. ^A rotating shaft is inserted into an attachment hole formed in the boss portion, and the boss portion is plastically deformed by caulking, so that the boss portion and the rotating shaft are ^{drawn} made close to each other, ^{whereby the} ~~vibrator~~ and it is integrally coupled to the rotating shaft.

According to the conventional vibration generating device ^{of type} like this, ^A since the vibrator itself is caulked and is directly coupled to the rotating shaft, as compared with another conventional ^{vibration generating device} one in which a vibrator is fixed to a rotating shaft through an adhesive or other coupling ^{manner} parts, there is ⁱⁿ a merit that it becomes possible to reduce the number of parts. ^{of the vibration generating device}

However, in the above conventional vibration generating device, since the attachment hole must be formed in the inside of the cylindrical boss portion of the vibrator, there has been a problem ⁱⁿ that when the vibrator is molded by pressing a powder raw material, it is difficult to fill the powder raw material, especially in a shaping die portion of the boss portion having a thin outer periphery, and the yield of the vibrator is lowered.

^{Additionally} Besides, for the purpose of satisfying a demand for miniaturization in recent years, an attempt has been made to

form the vibrator itself to be small. However, since the boss portion around the attachment hole becomes very thin, there has ^{been} also another problem ⁱⁿ that when caulking is ^{performed} made by ^{applying} a large force, a crack is likely to be generated, ~~and on~~ the other hand, if the caulking force is low, a desired pull-out strength can not be obtained, with the result that the adjustment of the caulking force becomes difficult.

~~when~~ ^{like} As another conventional vibration generating device, there has been a proposal that as shown in FIG. 10 and FIG. 11, ^A a groove portion 4, in which a rotating shaft 3 is fitted, is formed at the ^{a central} center portion of an eccentric load portion 2 of a vibrator 1. Side walls 5, which ^{define} ~~become~~ both side edge portions of the groove 4, are integrally formed ^{with and extend} by bulging from the eccentric load portion 2 along the groove portion 4. The ^{central} center portions of tip portions of the side walls 5, ^{an} in the axial line direction, are caulked from an opening side of the groove portion 4 ^{toward} to a bottom side ^{thereof} by a caulking punch 7. ^{The} in which its tip end is shaped into an R shape (or round shape) or a rectangular parallelepiped shape, so that ^{the vibrator 1 becomes} it is integrally coupled to the rotating shaft 3.

According to the conventional vibration generating device described above, there are merits ⁱⁿ that molding is easier ^{with} than the vibrator including the boss portion in which the attachment hole is formed, so that manufacture yield can be improved, ^E and even in the case where the vibrator 1 itself

becomes small, as compared with the case where the thin portion such as the outer periphery of the boss portion is caulked, there is little fear that a crack is generated.

However, in the conventional vibration generating device shown in FIGS. 10 and 11, when the tip portion end surfaces of the side walls 5 are caulked, the ~~whole~~^{entire} width dimensions from the sides of the groove 4 to the sides ~~of~~^{of the side walls 5} of outer peripheries 6 are crushed and, therefore, a high caulking force is required. However, since the rigidity of the portions of the side walls 5 at the sides ~~of~~^{because of} the groove 4 is high, ~~through~~^{performed} the rotating shaft 3, when plastic deformation is made, bulging ~~or deformation~~ is mainly caused toward the sides ~~of~~^{of} the outer peripheries 6 which become free ends, and as a result, there has been a problem, ^{of a} that a high pull-out strength ~~cannot~~^{being} be obtained. Besides, as a result ~~the~~^{of a} high caulking force ~~is~~^{being} required, when an attempt to increase a tungsten content is made to obtain a desired vibration, even in the case where the vibrator 1 is made small in diameter, it becomes brittle ~~in material~~, so that there has also been a problem that a crack is likely to be generated in the caulked side walls 5.

SUMMARY OF THE INVENTION

The present invention has been made in view of the above, and a principal object of the present invention is to provide an improvement in a vibration generating device for a small

wireless machine.

Another object of the present invention is to provide a vibration generating device of a small wireless machine in which manufacture of a vibrator is easy, the vibrator can be coupled to a rotating shaft of a motor at a high pull-out strength even ^{employing} by a low caulking force, and the whole device can be further miniaturized.

According to a first aspect of the invention there is provided a vibration generating device of a small wireless machine ^{which} includes a vibrator integrally coupled to a rotating shaft of a motor, wherein a groove portion in which the rotating shaft is fitted is formed in an eccentric load portion. ^{extending} Side walls ~~bulging~~ from the eccentric load portion, and forming both side edge portions of this groove portion, are ^{provided} ~~formed~~. And, ^{each of these} a portion of a tip portion end surface of ~~this~~ side wall, except ^{at} an outer peripheral portion of the side wall, and at a side of the groove portion, is caulked from an opening side of the groove portion ^{toward} ^{of the groove portion} to a bottom side, so that the vibrator is integrally coupled to the rotating shaft.

~~Besides,~~ ^{Accordingly,} According to a second aspect of the invention there is provided a vibration generating device of a small wireless machine in which a vibrator is integrally coupled to a rotating shaft of a motor, wherein an eccentric load portion is formed into a truncated fan shape in which a ^{central} ~~center~~ angle is less than 180° . ^{Accordingly, the eccentric load portion} ~~so that it~~ has a flat surface at a rotational

~~center~~ ^{central} side. A groove portion in which the rotating shaft is fitted is formed in the flat surface. Side walls forming both side edge portions of this groove portion are ~~formed~~ ^{provided}. A portion of the flat surface, except ^{at} an outer peripheral side portion of the side wall, and at a side of the groove portion, is caulked from an opening side of the groove portion ^{toward} to a bottom side, ^{of the groove portion} so that the vibrator is integrally coupled to the rotating shaft.

Further, according to a third aspect of the invention, which is a modification of the first aspect or second aspect of the invention, there is provided a vibration generating device of a small wireless machine, wherein a caulked portion formed into a concave shape in the tip portion end surface of the first aspect or the flat surface of the second aspect, respectively, ~~of the invention~~ ^{toward} by caulking from the opening side of the groove portion ^{thereof} to the bottom side is formed so that a length dimension at the side of the groove ^{portion} in an axial line direction is longer than a length dimension at an outer peripheral side. ^{of the groove portion}

^{According to a} ~~In the~~ fourth aspect of the invention, in a width dimension W of the tip portion end surface or the flat surface as recited in any one of the first to third aspects, from the side of the groove ^{portion} ^{thereof} to the outer peripheral side, a range of 0.25 W to 0.9 W from an edge portion at the side of the groove ^{portion} is caulked.

^{according to a}
 Further, ~~in the~~ fifth aspect of the invention, the groove portion of the vibrator as recited in any one of the first to fourth aspects is formed to have such a size as to internally contain a range exceeding a ^{central} ~~center~~ angle of 180° of the rotating shaft. ^{of W_1} And, an opening width W_1 of the groove portion is set so that a ratio ^(W_1/D) ~~(W_1/D)~~ to a diameter D of the rotating shaft of the motor ^{is} is in a range of 0.70 to 0.95.

In the vibration generating device of the small wireless machine as recited in any one of the first to fifth aspects of the invention, the rotating shaft of the motor is fitted in the groove portion, and in the tip portion end surfaces or the flat surfaces of the side walls forming both the side edge portions of this groove portion, the portion, ^{at} ~~except~~ the outer peripheral side portion and at the side of the groove ^{Portion,} is caulked ^{Accordingly,} ~~so that~~ ^{toward} to the bottom side of the groove portion. ~~so that~~ as compared with the conventional vibration generating device shown in FIG. 10 and FIG. 11, it becomes possible to couple the vibrator to the rotating shaft ^{employing} by a lower caulking force. ^{the same} At ~~this~~ time, the outer peripheral portion of the side walls ^{are} ~~is~~ not caulked ~~functions~~ as ~~a~~ wall portion ^{extended over} against the plastic deformation in the caulked portion, and consequently, the greater part of the caulked portion is ~~bulged~~ ^{extended over} to the groove ^{portion} side. Then, the vibrator is firmly fixed to the rotating shaft ^{at} by three points ^{of} of the bottom portion of the groove portion, and both ^{of} the ~~bulged~~ ^{extended} side walls. Thus, according to the vibration

generating device of the present invention, the manufacture of the vibration generating device is easy, and further, it is possible to couple the vibrator to the rotating shaft of the motor at a high pull-out strength even by ^{employing} a lower caulking force.

From the above, according to the vibration generating device of the present invention (as recited in any one of the first to fifth aspects), since the vibrator can be firmly fixed to the rotating shaft of the motor by ^{employing} a lower caulking force than ^{that of} the prior art, it is possible to realize the miniaturization and lightening of the vibrator, ^{as well as} and the miniaturization and lightening of the vibration generating device and the ^{entirety} whole of the small wireless machine. ^{Additionally} Besides, ^{because} as a result the caulking load can be made small ~~and the~~ generation of a crack ⁱⁿ of the vibrator can be prevented, the productivity of the vibration generating device is improved, and it becomes possible to improve the vibration efficiency by realization of the high specific gravity of the vibrator.

Here, especially in the third aspect of the invention described above, the length dimension of the caulked portion in the axial line direction at the side of the groove ^{portion} where most portions are ^{extended toward} bulged to the side of the rotating shaft, becomes larger ^{than} that at the peripheral side ^{of the groove portion} which functions as the wall portion when the caulked portion is plastically deformed. ^{Accordingly} so that the vibrator can be coupled to the rotating

shaft of the motor at a high pull-out strength by ^{employing} a lower caulking force. In addition, it becomes possible to use ^a the caulking punch which can be easily manufactured and has a circular shape in cross section, and the use life of the caulking punch can be greatly ^{lengthened} ~~elongated~~.

^{the} A fourth aspect of the invention is based upon any one of the first to third aspects of the invention described above. Namely, in the tip portion end surface or the flat surface of the side wall, when the portion, except ^{at} the outer peripheral side portion ^{of the groove portion} and ^{at} the groove side ^{toward} is caulked to the bottom side of the groove portion, in the width dimension W of the tip portion end surface or the flat surface from the groove side to the outer peripheral side ^{of the groove portion}, it is preferable to caulk the range of 0.25 W to 0.9 W from the edge portion of the side of the groove portion. At this time, in the case where the caulking width dimension is small, it is sufficient if the caulking length dimension in the axial line direction is made large, and on the contrary, in the case where the caulking width dimension is large, even if the caulking length dimension in the axial line direction is small, a sufficient pull-out strength can be obtained. The range of caulking is limited to the range of 0.25 W to 0.9 W because, if the range is smaller than 0.25 W ~~it~~ it becomes difficult to obtain a sufficient plastic deformation amount to firmly fix the vibrator to the rotating shaft of the motor, ^{and} ~~while~~ if the range ~~is~~ exceeds 0.9 W ~~the~~

foregoing function ^{of} ~~as~~ the wall portion ^{counter-acting} ~~against~~ the plastic deformation of the caulked portion is decreased, and as a result, the outer peripheral portion is also forcibly deformed outwardly ^{such that} and therefore the pull-out strength is lowered.

^{Additionally} Besides, the shapes of the side walls may be formed so that the ^{entirely} ~~whole~~ of the groove portion becomes U-shaped by erecting the side walls from both ~~the~~ side edges. In this case, in the state where the rotating shaft is fitted in the groove portion, the rotating shaft is internally contained in the groove portion within the range of a ^{central} ~~center~~ angle of 180° . On the other hand, like ^{with} the fifth aspect of the invention, when the groove portion of the vibrator is formed to have such a size that the range of the ^{central} ~~center~~ angle of 180° or more of the rotating shaft is internally contained, and the opening width W_1 of the groove portion is set so that the ratio ^{of W_1} ~~(W_1/D)~~ to the diameter D of the rotating shaft becomes ^{(W_1/D) within} in the range of 0.70 to 0.95 ^{as a result of} ~~by~~ the plastic deformation of the side wall after caulking, it is possible to fill the opening portion of the groove portion more effectively and to firmly fix the vibrator, ^{which} ~~so that~~ it is preferable.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a front view showing a caulking state according to a first embodiment of the present invention.

FIG. 2 is a longitudinal sectional view of a vibrator

of FIG. 1.

FIG. 3 is a perspective view showing the first embodiment of the present invention.

FIG. 4 is a front view showing the shape of a vibrator according to a second embodiment of the present invention.

FIG. 5 is a front view showing a state where the vibrator of FIG. 4 is caulked.

FIG. 6 is a front view showing the shape of a vibrator according to a third embodiment of the present invention.

FIG. 7 is a longitudinal sectional view of the vibrator shown in FIG. 6.

FIG. 8 is a perspective view showing a fourth embodiment of the present invention.

FIG. 9 is a perspective view showing a modified example of the fourth embodiment.

FIG. 10 is a front view showing a caulking state in a conventional prior art vibration generating device.

FIG. 11 is a perspective view showing the conventional prior art vibration generating device caulked as shown in FIG. 10.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS (OF THE INVENTION)

(First Embodiment)

FIGS. 1 to 3 shows a vibrator 10 according to a first embodiment of the present invention. The vibrator 10, which

is made of a high specific gravity metal molded ^{performing} by a powder metallurgical technique, has a substantially fan-shaped cross section with an axial line 0 as the center, and ^{an eccentric} ~~(the whole)~~ fan-shaped portion ^{extending} ~~(eccentric)~~ from the axial line 0 becomes or serves as an eccentric load portion 11. In the vibrator 10, a groove portion 13 in which a rotating shaft 12 of a motor is fitted, and which has a bottom portion of a ^{semi-circular shape} ~~(semicircle)~~ almost equal to the diameter of the rotating shaft 12, is formed at the ^{central} ~~(center)~~ portion of an outer peripheral arc which depicts the fan shape of the eccentric load portion 11. Further, side walls 14 which ^{extend} ~~(bulge)~~ from the eccentric load portion 11 in parallel with each other, and ^{define} ~~(become)~~ opposed side edge portions of the groove 13 ^{portion,} ~~are~~ integrally formed at both ~~(the)~~ side edge portions of the groove portion 13. In this kind of vibrator 10, generally, an arc radius of the eccentric load portion 11 is as ~~very~~ small as several mm, and consequently, it is difficult to distinguish between vibrators of different sizes, so that concave identification marks 16 of various shapes (circle in the drawing) indicating the size of the vibration generating device 10 are formed at both end surfaces of the eccentric load portion 11.

Then, in a tip portion end surface 14a of the side wall 14, ^{a central} ~~and at the center~~ portion, ^{but not at} ~~except~~ both end portions in the direction of the axial line 0, a portion 14c, ^{at} ~~except~~ an outer peripheral side portion 14b of the side wall 14 and at the side

of the groove 13, is caulked by a rectangular parallelepiped caulking punch 15 from an opening side of the groove 13 to a bottom side ^{there} so that the above vibrator 10 is integrally coupled to the rotating shaft 12. Here, in a width dimension W of the tip portion end surface 14a from the side of the groove portion 13 to ^{on} the outer peripheral side, the portion 14c to be caulked at the side of the groove portion 13 is set in the range of 0.25 W to 0.9 W from the edge portion at the side of the groove 13.

~~Incidentally,~~ ^{steel} The rotating shaft 12 can be made of stainless, for example, SUS 420 or the like. ~~Besides,~~ ^{performing} The vibrator 10 is preferably molded by using an ultra heavy alloy material of a specific gravity of about 17 to 19 g/cm³, for example, W-Ni system, W-Ni-Fe system, W-Ni-Cu system, W-Mo-Ni-Fe system, or the like, and by a powder metallurgical technique. Specifically, a mixture powder of a composition made of W powder of 89 to 98 weight %, and Ni powder of 1.0 to 11 weight %, or a mixture powder of a composition containing the W powder and Ni powder in the above range of weight %, and one or more kinds of Cu of 0.1 to 6 weight %, Fe powder of 0.1 to 6 weight %, Mo powder of 0.1 to 6 weight %, and Co powder of 0.1 to 5 weight % is or are compacted into a fan plate shape ^{applying} by a pressure of 1 ton/cm² to 4 ton/cm², and ^{having} this compact is liquid phase sintered in a hydrogen gas stream ~~of~~ a dew point of 0°C to -6°C or ⁱⁿ an ammonia decomposition gas, and thereafter,

the compact

it is further heated in the temperature range of 700°C to 1430°C \pm 30°C in a vacuum, neutral or reducing atmosphere, and then, a heat treatment ^{to} of rapidly cooling ^{the compact} it to at least 300°C at a cooling rate of 40°C/min or more is performed.

In the composition of ^{such a} the vibrator 10 ~~like this~~, when the W (tungsten) content exceeds 98 weight %, the specific gravity becomes high although the malleability (or ductility) is lowered, and in the case where ^{the W content} it is less than 89 weight %, a predetermined specific gravity cannot be obtained, and ^{thus} it ~~becomes disadvantageous as this kind of vibrator.~~ ^{the} ~~Besides,~~ ^{exhibits disadvantages}

^A Also in the case where the Ni (nickel) content exceeds 11 weight %, a predetermined specific gravity cannot be obtained, and in the case where ^{the Ni content} it is less than 1.0 weight %, sintering does ^{result} not proceed. Further, although Co (cobalt) has the same effect as Ni, ^{the Co content} when it is less than 0.1 weight %, a sufficient effect ^{its} of the addition cannot be obtained, and on the other hand, even if ^{the Co content} it exceeds 5 weight %, an adequate effect cannot be obtained and the manufacture ^{of the vibrator non-economical} becomes uneconomical. When the Cu powder and Fe powder are contained, although a sintering temperature can be lowered, a predetermined specific gravity cannot be obtained in a range over the ^{above-mentioned} upper limit value.

According to the vibration generating device of the small wireless machine having the above structure of composition, the rotating shaft 12 of the motor is fitted in the groove ^{portion} 13, and in the tip portion end surfaces 14a of the side walls 14

forming both ~~the~~ side edge portions of the groove portion 13, except ^{at} the outer peripheral side portion 14b, in the width dimension W from the side of the ^{portion} groove 13 to the ^{an} outer peripheral side, ^{thereof} the portion 14c in the range of 0.25 W to 0.9 W from the edge portion at the side of the ^{portion} groove 13 is caulked by the caulking punch 15 toward the bottom side of the groove ^{portion} 13, so that as compared with the conventional vibration generating device as shown in FIGS. 10 and 11, it is possible to couple the vibrator to the rotating shaft ^{applying} by a lower caulking force.

At this time, since the outer peripheral ^{side} portion 14b of the side wall, which is not caulked, functions as a wall portion against the plastic deformation ^{of} in the caulked portion 14c, the greater part of the caulked portion 14c ^{extends over} ~~is bulged to~~ the side of the ^{portion} groove 13, and consequently, the vibrator 10 can be firmly fixed to the rotating shaft 12 ^{at} by three points ^{i.e.} of ^{portion} the bottom ^{caulked portions 14c.} portion of the groove 13, and both ~~the bulged side walls.~~ Thus, manufacture of the vibrator 10 is easy, and the vibrator can be coupled to the rotating shaft of the motor at a high pull-out strength even by ^{applying} a low caulking force.

According to the vibration generating device described above, since the vibrator 10 can be firmly fixed to the rotating shaft 12 ^{applying} by a lower caulking force ^{that of} than the prior art, miniaturization and lightening of the vibrator 10 itself, and further, miniaturization and lightening of the vibration

generating device and the ^{entirety} whole of the small wireless machine can be realized. Besides, since the caulking load is ~~made~~ small and ~~the~~ generation of a crack in the vibrator 10, especially at the side wall 14 can be prevented, it becomes possible to increase the productivity of the vibration generating device and to improve the vibration efficiency through realization of the high specific gravity of the vibrator 10.

[Experiment]

An experiment was ^{performed} made in which the pull-out strength of the vibrator 10 fixed to the rotating shaft 12, ^{performing} by the caulking operation according to the present invention, was compared with the pull-out strength of the conventional vibrator 1 fixed to the rotating shaft 3 ^{performing} by the conventional caulking ^{technique as} shown in FIGS. 10 and 11. In the comparison experiment, by using the vibrators 1 and 10 and the rotating shafts 3 and 12, respectively, having the same shape, five vibration generating devices were produced in each group.

In the above vibrators 1 and 10 used for the experiment, the outer diameter of each of the eccentric load portions 2 and 11 was 3 mm, the length in the direction of the axial line 0 was 5 mm, the inner diameter of each of the grooves ^{portions} 4 and 13 was 0.4 mm, the height ~~dimension~~ of each of the side walls 5 and 14 from the bottoms of the grooves ^{portions} 4 and 13 was 1.1 mm, the width ~~dimension~~ W of each of the side walls 5 and 14 was

0.7 mm, and the outer diameter ~~dimension~~ of each of the rotating shafts 3 and 12 was 0.8 mm.

~~Besides,~~ ^{In} the conventional vibration generating device, the side wall 5 extending over the ^{entire} ~~whole~~ width dimension was crushed ^{along} ~~in~~ a length of 2.6 mm in the axial line direction by the caulking punch 7. On the other hand, in the vibration generating device of the present invention, by using the caulking punch 15 with a width size of 1.4 mm, ~~the range~~ (0.43 W) ^{i.e.} ~~of~~ 0.3 mm of the respective side walls 14 from the side of the groove portion 13 was crushed ^{along} ~~in~~ a length of 2.0 mm in the axial line direction.

With respect to the five vibration generating devices in each group obtained in this way, a pull-out test of the conventional vibrators 1 and the inventive vibrators 10 was carried out, and it was found that while the extracting force (kgf) was 5.3, 4.9, 5.5, 5.5, 5.4 (average 5.3) ^{for} ~~in~~ the conventional vibration generating device, the extracting force (kgf) was 10.3, 11.0, 10.5, 10.3, 10.2 (average 10.5) ^{for} ~~in~~ the vibration generating device of the present invention. That is, in spite of the fact that the caulking length in the axial line direction was shorter by 0.6 mm, ^{of} ~~the~~ pull-out strength ^{that of} ~~the~~ almost twice the conventional pull-out strength was obtained.

(Second Embodiment)

FIGS. 4 and 5 show a second embodiment of the present

invention, and In this vibration generating device, a groove portion 22 having a bottom portion 22a of a substantially semicircular shape is formed in an eccentric load portion 21 of a vibrator 20, and side walls 23 forming both side walls of this groove portion 22 are integrally formed so as to cover an exposed portion of a rotating shaft 24 of a motor fitted in the groove ^{portion} 22 with an interval ^{on} from both sides in the direction of an axial line O. As a result, the groove portion 22 of the vibrator 20 is formed to have such a size as to internally contain the range of a ^{central} ~~center~~ angle ^{of} 180° or more of the rotating shaft 24. An opening width W_1 of the groove portion 22 between the ^{opposing} ~~opposite~~ side walls 23 is set so that a ratio ^{of W_1} ~~(W_1/D)~~ to a diameter D of the rotating shaft 24 ^(W_1/D) is in the range of 0.70 to 0.95.

As a specific example in which such a range is obtained, in the case where the diameter D (mm) of the rotating shaft 24 is 0.4, 0.5, 0.6, 0.7, 0.8, 0.9 or 1.0, it is sufficient if the opening width W_1 (mm) of the groove portion 22 between the side walls 23 is set to 0.3, 0.4, 0.5, 0.6, 0.7, 0.8, or 0.9.

As shown in FIG. 5, in a tip portion end surface 23a of the side wall 23, and at the ^{central} ~~center~~ portion ^{thereof, but not at} ~~except~~ both ends ^{thereof,} in the direction of the axial line O, a portion 23c ^{which does not include} ~~except an~~ outer peripheral side portion 23b of the side wall 23, and at the side of the groove ^{portion} 22 is caulked by a rectangular

parallelepiped caulking punch 25 from an opening side of the groove ^{portion} 22 to a bottom side ^{thereof}, so that the above vibrator 20 is integrally coupled to the rotating shaft 24. At this time, similarly to the first embodiment, in a width dimension W of the tip portion end surface 23a from the side of the groove portion 22 ^{towards} to the outer peripheral side, the caulked portion 23c at the side of the groove ^{portion} 22 is set so that it is in the range of 0.25 W to 0.9 W from an edge portion at the side of the groove ^{portion} 22. ^{of the tip portion end surface 23a}

Also in the vibration generating device having the above structure shown in FIGS. 4 and 5, the same function and effect as those of the first embodiment can be obtained, and especially in the vibrator 20 of the second embodiment, the groove portion 22 of the vibrator 20 is formed to have such a size as to internally contain the range of a ^{central} ~~center~~ angle of 180° or more of the rotating shaft 24. ^{and} The opening width W_1 of the groove portion 22 is set so that the ratio ^{of W_1} ~~(W_1/D)~~ to the diameter D of the rotating shaft 24 ^(W_1/D) is in the range of 0.70 to 0.95, so that the vibrator 20 is firmly fixed to the rotating shaft 24 ^{at} by three points ^{i.e.} of the bottom portion 22a of the groove portion 22, and bottom portions 23d of the side walls 23. As a result, it is possible to fix the vibrator 20 to the rotating shaft 24 ^{applying} by a lower caulking force.

(Third Embodiment)

FIGS. 6 and 7 show a vibrator 30 of a third embodiment.

and ^{entirely} ~~In~~ this vibrator 30, the ~~whole~~ of an eccentric load portion 31 is formed into a shape of a truncated fan-shaped cross section in which a ^{central} ~~center~~ portion, indicated by a dotted line in the drawing, of a fan shape with a ^{central} ~~center~~ angle of less than 180° is removed. By this, flat surfaces 32 are formed at the ^{rotational central} ~~rotation-center~~ side of the vibrator 30, and a U-shaped groove portion 33, in which the rotating shaft is fitted, is formed at the center of ^{these surfaces} ~~this flat portions~~ 32. As a result, side walls 34 forming both side edge portions of the groove portion 33 are formed at both sides of this groove portion 33, and ^{an} ~~an~~ outer peripheral surface 34a of the side wall 34 is formed into a slant ^{ed} flat surface shape which is continuous with an outside surface 31a of ^{the} ~~this~~ eccentric load portion 31, and leads to an arc-shaped outer peripheral surface 31b.

Similarly ~~to~~ to the first embodiment, in the flat surface 32 which becomes a tip portion end surface of the side wall 34, and at the ^{central} ~~center~~ portion ^{thereof, but not at} ~~except~~ both end portions, in the axial line direction, a portion of the side wall 34, ^{which does not} ~~except~~ ^{include} a portion at the side of the outer peripheral surface 34a, at the side of the groove portion 33 is caulked by a rectangular parallelepiped caulking punch from the opening side of the groove portion 33 to the bottom side, ^{thereof} ~~so~~ so that the above vibrator 30 is integrally coupled to the rotating shaft. Also in this vibrator 30, in the width dimension W of the flat surface 32 from the side of the groove portion 33 ^{towards} ~~to~~ the outer peripheral

of the flat surface 32
side, the caulked portion at the side of the groove 33 is set so that it is in the range of 0.25 W to 0.9 W from the edge portion at the side of the groove 33.

Also in the vibration generating device made of the above structure of the third embodiment of the invention, the same function and effect as those shown in the first embodiment can be obtained, and further, the whole of the vibrator 30 is formed into the shape having the central angle of less than 180° , and having the truncated fan-shaped cross section in which the flat surfaces are central portion 32 is formed at the center portion. Therefore, there are such advantages that a metal mold shape for forming the vibrator 30 by a powder molding technique is simplified, and manufacture becomes easy. Further, since the center of gravity can be set at a position decentered (or eccentric) from the rotating shaft to the outside, a desired vibration can also be obtained.

(Fourth Embodiment)

FIGS. 8 and 9 show a vibrator 40 according to a fourth embodiment of the invention and its modified example, respectively. The vibrator 40 has substantially the same shape as that shown in the first embodiment, and the entire of a fan-shaped portion that is eccentric from its axial line is an eccentric load portion 41. In the vibrator 40, a semicircular groove portion 43, in which a rotating shaft 42 of a motor is fitted and which has a bottom portion with a size substantially equal to a diameter of the rotating shaft 42, is formed at the

^{central}
~~center~~ portion of an outer peripheral arc which depicts the fan shape of the eccentric load portion 41. Side walls 44 ^{extending} ~~bulging~~ from the eccentric load portion 41 in parallel with each other, and ^{defining} ~~becoming~~ both side edge portions of the groove ^{portion} 43, are integrally formed at both side edge portions of the groove portion 43.

Then, in a tip portion end surface 44a of the side wall 44, and at the ^{central} ~~center~~ portion ^{thereof, but not at} ~~except~~ both end portions ^{thereof} in an axial line direction, a portion 44c of the side wall 44, ^{which does not} ~~except~~ an outer peripheral side portion 44b, ^{of the side wall 44,} and at the side of the groove 43 is caulked by a cylindrical caulking punch 45 from an opening side of the groove ^{portion} 43 to a bottom side, ^{thereof} so that the above vibrator 40 is coupled to the rotating shaft 42. Here, as a result of caulking by the cylindrical caulking punch 45, ~~the~~ concave caulked portions 44c formed at the tip portion end surfaces 44a, respectively, become substantially semi-circular, and are formed so that a length dimension L in the axial line direction at the side of the groove portion 43 becomes larger than a length dimension at ^{an} ~~the~~ outer peripheral side. ^{of the concave caulked portions 44c}

~~Besides,~~ ^{In} a vibrator 40 shown in FIG. 9, at the ^{central} ~~center~~ portion of a tip portion end surface 44a, a portion 44c' of a side wall 44, ^{which does not include} ~~except~~ an outer peripheral side portion 44b, ^{of the side wall 44,} and at the side of a groove ^{portion} 43 is caulked by a caulking punch 46. ^{the caulking is performed such that} ~~in a state where~~ a corner portion of the caulking punch 46, having ^{as an} ~~the~~ a square section, is positioned at the outer peripheral side, ^{of the caulking punch 46}

the vibrator 40 became -
so that it ~~is~~ integrally coupled to a rotating shaft 42. *Accordingly*
~~this~~, the concave caulked portion 44c' formed by caulking with
the caulking punch 46 *exhibits* ~~is formed into~~ a triangular shape having
a bottom side at ^athe side of the groove ^{portion} 43.

As a result, according to the above vibration generating
devices shown in FIG. 8 and FIG. 9, the same function and effect
as those shown in the first and second embodiments are obtained,
and further, the length dimensions of the caulked portions 44c
and 44c' are formed so that the dimension at the side of the
groove 43, ^{portion} ~~where most parts are bulged~~ *the material extends over* to the side of the rotating

shaft 42, becomes larger than that at the outer peripheral side *of the*
caulked portions, which
functioning as a wall portion when the caulked portions 44c

and 44c' are plastically ~~deformed~~ *Accordingly* ~~so that~~ the total volume *of the*

side wall 44 to be plastically deformed becomes small, and a high pull-
out strength can be obtained by ^{employing} a further low caulking force.

In addition, it is possible to use the caulking punch 45, which
is easily manufactured and has the circular section, and it
is also possible to greatly enlarge the use life of the caulking
punches 45 and 46.

With respect to the vibrators 10, 20, 30 and 40 in the
first to fourth embodiments of the invention, although the
description has been made only ^{with regard to} on the case where the eccentric
load portions 11, 21, 31, and 41 ^{have} ~~having~~ the substantially
fan-shaped section or truncated fan-shape section ~~are formed~~,
the invention is not limited to this, ^{and also} ~~but~~ it is possible to

use some other modified structures including eccentric load portions of various shapes, for example, a substantially semi-circular section or the like.

~~Besides,~~ ^A also with respect to the groove portions 13, 22, 33, and 43, the bottom portions are not limited to the semi-circular shape, but they can be formed ^{of} ~~into~~ various sectional shapes, such as a substantially square section or a substantially trapezoid ^A section.

[Effect of the Invention]

As described above, according to the vibration generating device of the small wireless machine as recited in any one of first to fifth aspects of the invention, since the vibrator can be firmly fixed to the rotating shaft of the motor ^{employing} by a lower caulking force than ^{that associated with} the prior art, miniaturization and lightening of the vibrator, and miniaturization and lightening of the vibration generating device and the ^{entirety} ~~entire~~ of the small wireless machine can be realized. ^{Also,} ~~and~~ a caulking load can be made small and the generation of a crack of the vibrator can be prevented, and consequently, ~~the~~ productivity of the vibration generating device can be improved. ^{Also,} ~~and~~ it becomes possible to improve the vibration efficiency by realization of the high specific gravity of the vibrator.

Here, especially according to the invention as recited in the third aspect of the invention, the vibrator with a high pull-out strength can be coupled to the rotating shaft of the

motor by a ^{applying} further low caulking force, and Further, it becomes possible to use the caulking punch which is easily manufactured and has the circular section, and the use life of the caulking punch can be greatly ^{lengthened} elongated.

^{Additionally} Besides, according to the invention as recited in the fifth aspect of the invention, the groove portion of the vibrator is formed to have such a size as to internally contain the range of the ^{central} ~~center~~ angle of 180° or more of the rotating shaft, ^{AKO,} and the opening width W_1 of the above groove portion is set so that the ratio ^{+ W_1} (W_1/D) to the diameter D of the rotating shaft ^{Accordingly,} is in the range of 0.70 to 0.95, ~~so that~~ it is possible to obtain an effect that after caulking, the opening portion of the groove portion is further effectively filled by the plastic deformation of the side wall, and the vibrator can be firmly fixed ^{to the shaft of the motor}.